

## **ABSTRACT**

The present invention relates to an automated system for storing pallets for loading green tires, taking said pallets into a warehouse and taking said pallets out of the  
5 warehouse which stores automatically the pallets on which green tires are loaded to take the pallets into a warehouse and to take the pallets out of the warehouse storing and awaiting the green tires when the green tires manufactured by assembling various half-finished products in the building machine used in a forming process when the tires are manufactured are introduced into the vulcanizing machine used in a vulcanizing process as  
10 a subsequent process, and the automated system according to the present invention comprises a conveyor section 3 for taking the pallet 2 on which the green tire 1 subjected to a forming process is loaded into the warehouse; a gantry robot section 5 for transferring said pallet 2 to be taken out of the warehouse to a conveyor section 4 for taking the pallet out of the warehouse when the pallet is taken out of the warehouse while the warehoused  
15 pallet 2 is transferred to a location on which the warehoused pallet is stacked and stored; and a conveyor section 4 for taking the pallet out of the warehouse by said gantry robot 5, in which the above gantry robot 5 is operated in the directions of X axis 6, Y axis 7 and Z axis 8, so that said pallet is selectively transferred and positioned.